

Cutting Blade Maintenance

Operating an attachment with dull or improperly maintained cutting blades will result in poor cutting, material jamming and inefficient processing.


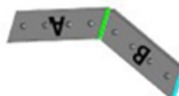


But, did you also know that operating an attachment with excessively worn blades or incorrect blade gaps could lead to premature cylinder failure and structural damage, resulting in expensive repairs and down time?

Luckily, such events can be easily prevented by implementing the following cutting blade maintenance tips.

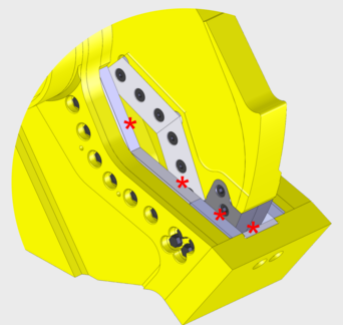


Check blade bolt torque, gaps and wear every day while at ambient temperature before start-up. Re-torque loose and replace broken bolts.

Check blades every eight hours of operation for wear, damage and visible signs of cracking. Rotate blades when the cutting edges are worn to a 1/8" (3mm) radius, see rotation sequence below. Blades must be replaced when all four edges are worn to a 1/8" (3mm) radius.

Original Blade Configuration	First Rotation Rotate both blades end-for-end	Second Rotation Rotate both blades front-to-back and exchange seat positions	Third Rotation Rotate both blades end-for-end
			

Blade gaps can be simply checked with blade shims. If the minimum blade gap for instance is 0.010", a 0.010" shim should pass through, but a 0.005" together with a 0.010" (0.015") should not. If it does, add shims between the blade and adjustment plate of the lower jaw to close the gap. The image on the right shows shear blade gap locations.



Check the [Safety and Operator's Manual](#) for the correct blade gaps for the specific attachment you are working on. Do not set blade gaps tighter than what is specified in the manual. Doing so will cause blade heating, expansion and interference, which is evident if blade faces look rough, have material build-up (blue streaks), or spider web looking surface cracks.

Cutting blade maintenance questions? Contact Tim at 218-349-5755, talseth@genesisattachments.com